

Work Order ID 83526

April-19-12 10:34:03 AM

83526

Page 1

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH

Stop *NS2*

Start Date: 19/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/19* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

*Scatter
JB*

for MLJ 12-5-2

83526 LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ID 83526

4:03 AM

83526

Page 2

D350-636-011

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N900040100

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Stop *NS2*

Item : Skidtube LH

Start Date: 19/04/2012 Start Qty: 1.00

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1

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

JH 12-04-23

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M120854 BE 12/04/23

12-Grind welds flush as per Dwg D2750 901 12-04-24

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S. 2/14/26

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. 2/14/26

W/O:		WORK ORDER CHANGES					
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Page 4

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

7/6 12-4-25

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

1 0 BE12-0425

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per OSI 015

A/R Sikaflex-291

batch: 71721221

exp. date: 2013-01-01

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & OSI004 (welding instructions on sheet 8)

A/R Aluminum Rod

batch: M 120854

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

12/CC 12-4-30

SAD
12-04-2012

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Page 6

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Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

 **OK/CC 12-4-30****S12/04/30****S12/04/30**

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April-19-12 10:34:03 AM

83526

Page 7

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 19/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

26 12-4-30

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-20 3200F 8-50

IX 12/05/01

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

IX 12/05/02

M121134

W/O:		WORK ORDER CHANGES					
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Page 8

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Required Date: 03/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

220

HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

1 2 28 12/05/02

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

0.00

0.00

1 2 28 12/05/02

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 12/221

EXP DATE: 13/01

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 110348

5-Coat all exposed fasteners with "LPS Procyon" batch: 714596

W/O:		WORK ORDER CHANGES					
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April-19-12 10:34:03 AM

83526

Page 9

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Accept

N900040100

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Stop ***NS2***

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

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83526

Page 10

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

270

Packaging

Packaging

Packaging

Memo

Package as per PPP D350-636-011

0.00

0.00

Reo I

12/5/38

280

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

12/5/79

112-05-3

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-19-12 10:34:08 AM

Page 1

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC
 seq110 DD verf:EC
 DD verf:EC
 IPP Rev:P 10.06.22 revise
 IPP Rev:Q 10.10.01 as per IIN revH

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1 *D3492-1* Plug		Manufactured	No			230	Each	261.0000	8	8			
									**	8	(2P)	12/05/02	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				14					
				69531				8					
				74444				2					
				76235				4					
				FP-A				247					
				81963				47					
				83098 ✓				200					
D3492-3 *D3492-3* Plug		Manufactured	No			230	Each	213.0000	8	8			
									**	8	(2P)	12/05/02	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP-A				213					
				81967				13					
				83099 ✓				200					

W/O:		WORK ORDER CHANGES					
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April-19-12 10:34:08 AM

Page 2

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

NAS1611-010

NAS1611-010

O-RING

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

Purchased

No

230

Each

295.0000

8

8

**

8 (29) 12/05/02

Location

Loc Qty

Loc Code

FP001

295

110915

14

117460

8

118077

1

118612

3

119438

47

120986

36

121166

36

121259 ✓

50

121415

100

Purchased

No

250

Each

199.0000

2

2 ✓

**

29

Location

Loc Qty

Loc Code

ST298

199

118078

34

119307

65

120308

100

119307

Manufactured

No

110

Each

30.0000

1

1

**

BE 12/04/23

Location

Loc Qty

Loc Code

LG002

30

62715

1

70881

1

78900

28

D2744

D2744

Cap

April-19-12 10:34:08 AM

Shop Packet Print

Page 2

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Page 3

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Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

38.0000

1

**

1

12-04-23

D2600-3-BENT

Extrusion Bent

Location

Loc Qty

Loc Code

LG

38

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

6

83305

17

D2743

Manufactured No

160

Each

281.0000

8

**

8

BE 12-04-26

D2743

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

-3

81965

207

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

April-19-12 10:34:08 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 4

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

D2739

350 I Beam

Manufactured No

160

Each

6.0000

1

1

**

SAD 12-04-25

Location

Loc Qty

Loc Code

LG

6

72155

1

81508

1

82123

2

82124

2

383449

①

Manufactured No

160

Each

46.0000

4

4

**

BE12-04-26

Location

Loc Qty

Loc Code

LG

44

82016

44

LG001

2

78800

2

4

D3490-3

D3490-3

Cross Bolt Spacer

D3490-1

D3490-1

Cross Bolt Spacer

Manufactured No

160

Each

64.0000

4

4

**

BE12-04-26

Location

Loc Qty

Loc Code

LG

55

81976

55

LG001

9

62450

2

74875

4

77042

3

4

April-19-12 10:34:08 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 5

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased No

220

Each

2,040.000

38

38

AI S4-1032-225

Insert

**

38

(28)

12/05/02

Location

Loc Qty

Loc Code

ST281

2017

108696

146

110768

62

118386

55

118966

68

121269 ✓

1686

ST282

23

120410

10

120451

13

D3793-3

Manufactured No

230

Each

22.0000

1

1

D3793-3

Wearshoe

**

1

(28)

12/05/02

Location

Loc Qty

Loc Code

FP001

22

80434

10

82166 ✓

12

AN8C35A

Purchased No

230

Each

95.0000

1

1

AN8C35A

BOLT

**

1

(28)

12/05/02

Location

Loc Qty

Loc Code

FP002

94

115960

1

118286 ✓

43

121275

50

ST346

1

114442

0

115188

0

115960

1

April-19-12 10:34:08 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 6

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-1

D3793-1

Wearshoe

Manufactured No

230

Each

17.0000

1

1

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP001

17

78901

1

82171 ✓

16

Manufactured No

230

Each

5.0000

1

1

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP002

5

61689

1

75056

1

77021

3

Manufactured No

230

Each

15.0000

1

1

**

1

(2P)

12/05/02

Location

Loc Qty

Loc Code

FP002

15

74530

2

80436 ✓

13

D3794-3

D3794-3

Gasket

~~*~~~~*~~

April-19-12 10:34:08 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 7

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

AN6C44A

AN6C44A

BOLT

MS21083C8

MS21083C8

NUT

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

Purchased

No

230

Each

188.0000

4

4

**

4

(28)

12/05/02

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

186

120143

25

121013

11

121167 ✓

100

121440

50

Purchased

No

230

Each

135.0000

1

1

**

1

(28)

12/05/02

Location

Loc Qty

Loc Code

304

100

121185 ✓

50

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

30

120731

5

121011

25

April-19-12 10:34:08 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 8

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-25

D3536-25

Gasket

Manufactured No

230

Each

14.0000

1

1

**

1 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP

14

81342 ✓

14

Manufactured No

230

Each

155.0000

8

8

**

8 (2P) 12/05/02

Location

Loc Qty

Loc Code

FG

100

81874 ✓

100

ST072

55

68062

2

75548

53

Manufactured No

230

Each

17.0000

1

1

**

1 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP002

17

62239

2

82168 ✓

15

Manufactured No

230

Each

0.0000

38

38

**

38 (2P) 12/05/02

D3791-1

D3791-1

Wearplate

Manufactured No

230

Each

17.0000

1

1

**

1 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP002

17

62239

2

82168 ✓

15

Manufactured No

230

Each

0.0000

38

38

**

38 (2P) 12/05/02

AN960C10L

* NAS1149C0332 ✓
R

Purchased

No

230

Each

0.0000

38

38

**

38 (2P) 12/05/02

*AN960C10I *

washer

121509 ✓

April-19-12 10:34:08 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 9

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

108.0000

8

8

D2745

Bushing

**

8 (28) 12/05/02

Location

Loc Qty

Loc Code

FP

83260 ✓

6

79518

6

FP001

102

69529

1

76142

1

81964

100

AN3C5A

Purchased

No

230

Each

1,312.000

34

34

AN3C5A

Bolt

**

34 (28) 12/05/02

Location

Loc Qty

Loc Code

FP001

121068 ✓

7

115835

7

ST350

1305

116419

28

117343

13

117764

7

117872

2

119749

23

120423

232

1210168

500

121255

500

April-19-12 10:34:08 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 10

Work Order ID: 83526

83526

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

70.0000

3

3

D3537-1

Wearpad

**

3

(24)

12/05/02

Location

Loc Qty

Loc Code

FG

10

79833

10

FP002

60

69817

5

73716

53

81361

2

NAS1149C0832R

Purchased

No

230

Each

284.0000

1

1

NAS1149C0832R

WASHER

**

1

(24)

12/05/02

Location

Loc Qty

Loc Code

ST297

284

114915

284

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 11

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

445.0000

4

4

AN3C6A

BOLT

**

4 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

444

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693 ✓

352

NAS1611-013

Purchased

No

230

Each

170.0000

8

8

NAS1611-013

O-RING

**

8 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP001

170

116582

5

117291

2

117887

53

119623

36

120910

4

121166

20

121259 ✓

50

April-19-12 10:34:08 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 12

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

31.0000

1

1

D3535-25

Wearshoe

**

1 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP001

81357 ✓

31

62233

1

80331

3

81357

10

82156

17

D3794-1

Manufactured No

230

Each

31.0000

1

1

D3794-1

Gasket

**

1 (2P) 12/05/02

Location

Loc Qty

Loc Code

FP

82167 ✓

23

82167

23

FP002

8

75042

3

80435

5

MS21043-6

Purchased No

230

Each

729.0000

4

4

MS21043-6

NUT

**

4 (2P) 12/05/02

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

709

112314

3

117887

6

118384 ✓

200

120308

500

April-19-12 10:34:08 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 13

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

75.0000

2

2

✓

D3493-1

Washer

**

JB

Location

Loc Qty

Loc Code

ST050

75

70697

2

77573

1

78835

31

82023

41

~~12/05/02~~
2x 82023

MS21083C8

Purchased

No

250

Each

135.0000

2

2

✓

MS21083C8

NUT

**

121524JB

12/05/02

Location

Loc Qty

Loc Code

304

100

121185

50

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

30

120731

5

121011

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 14

Work Order ID: 83526

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83526

D350-636-011

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

109.0000

2

2

**

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

109

118758

3

120094

16

121067

20

121167

20

121275

50

121067

NAS1515H3L

Purchased

No

230

Each

154.0000

4

4

**

*NAS1515H3I *

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

114

118686

3

119438

1

120360

60

121243

50

D2741

Manufactured

No

250

Each

55.0000

1

1

**

D2741

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

65

71856

1

76984

14

79516

40

79516

April-19-12 10:34:08 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 10:34:08 AM

Page 15

Work Order ID: 83526

83526

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

41.0000

2

2

**

D3532-1

Spacer

Location

Loc Qty

Loc Code

ST053

41

78839

17

82041

24

1x 78839
1x 82041

12/05/02

April-19-12 10:34:08 AM

Shop Packet Print

Page 15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER
NO. 83526 MLJ

12/04/19

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-045	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F

SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

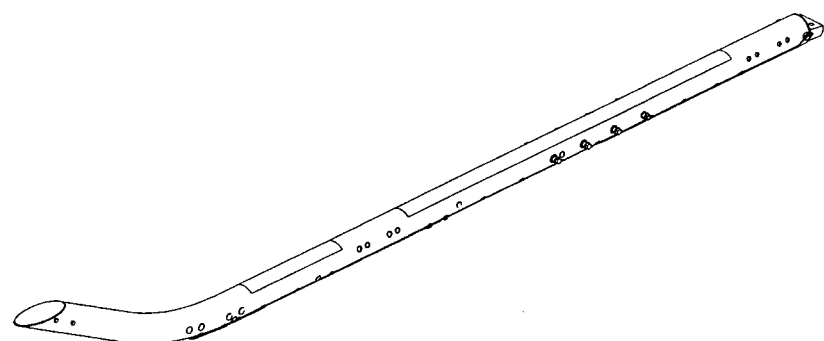
SCALE

NTS

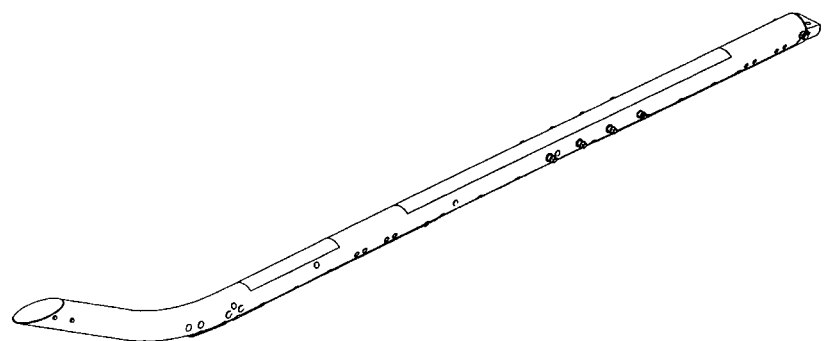
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

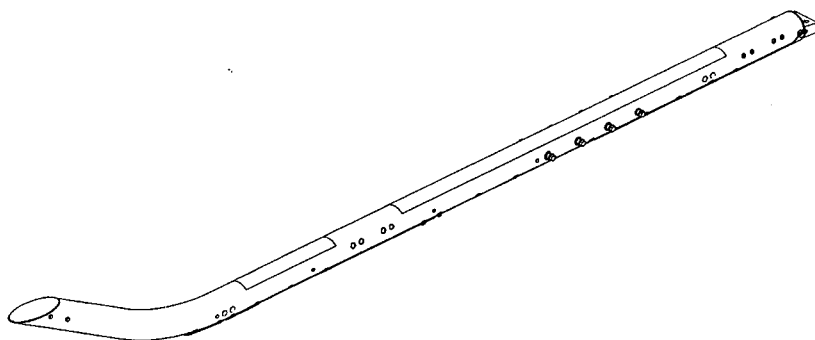


D2750-042 350 SKIDTUBE ASSEMBLY, RH

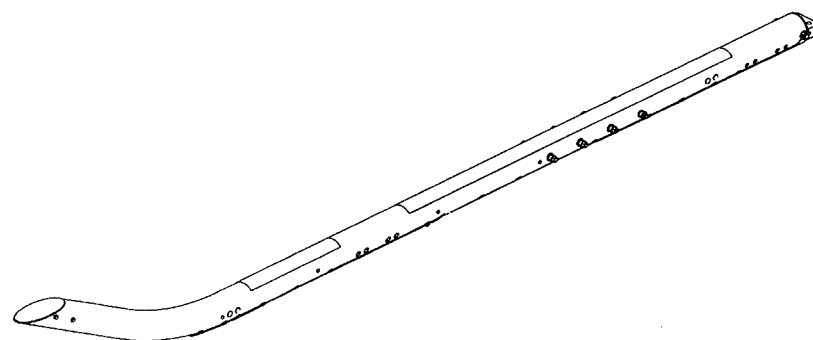
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MFG. APPR.	NA	SHEET 2 OF 11	
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	350 SKIDTUBE ASSEMBLY	NTS
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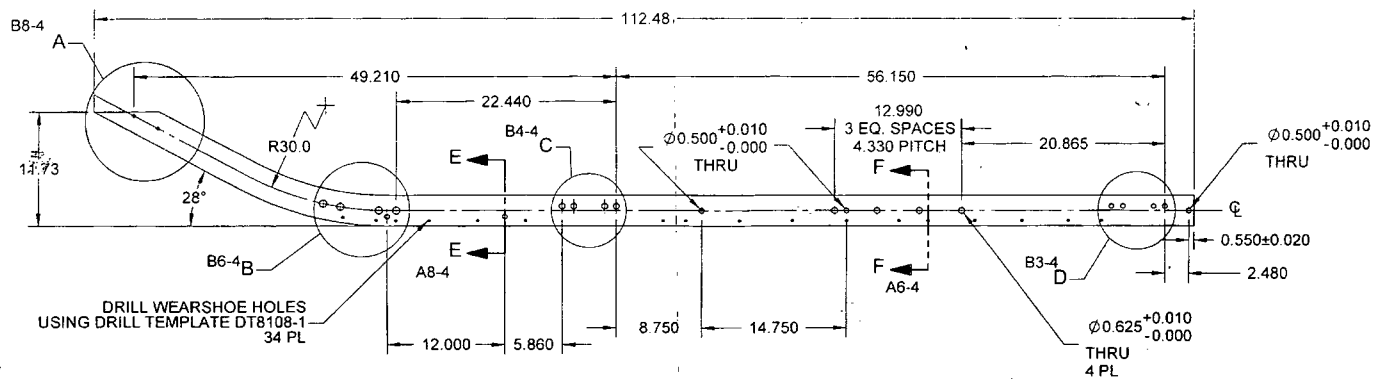
D2750-043 350 SKIDTUBE ASSEMBLY, LH



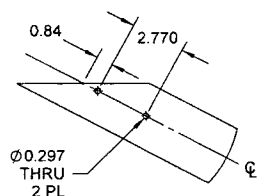
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/100

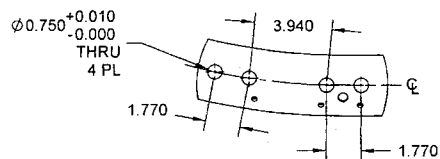
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MFG. APPR.	NA	D2750	SHEET 3 OF 11
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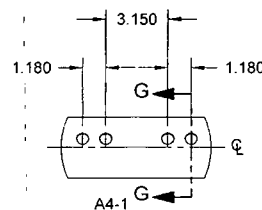
D2750-1 LH SKIDTUBE



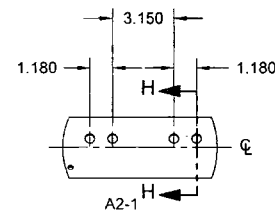
DETAIL A
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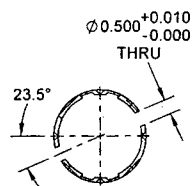
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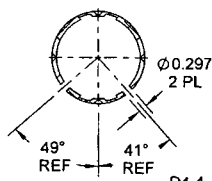
DETAIL C
SCALE 2X



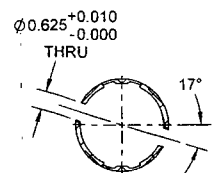
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SCALE 2X



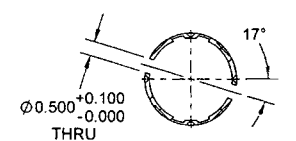
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



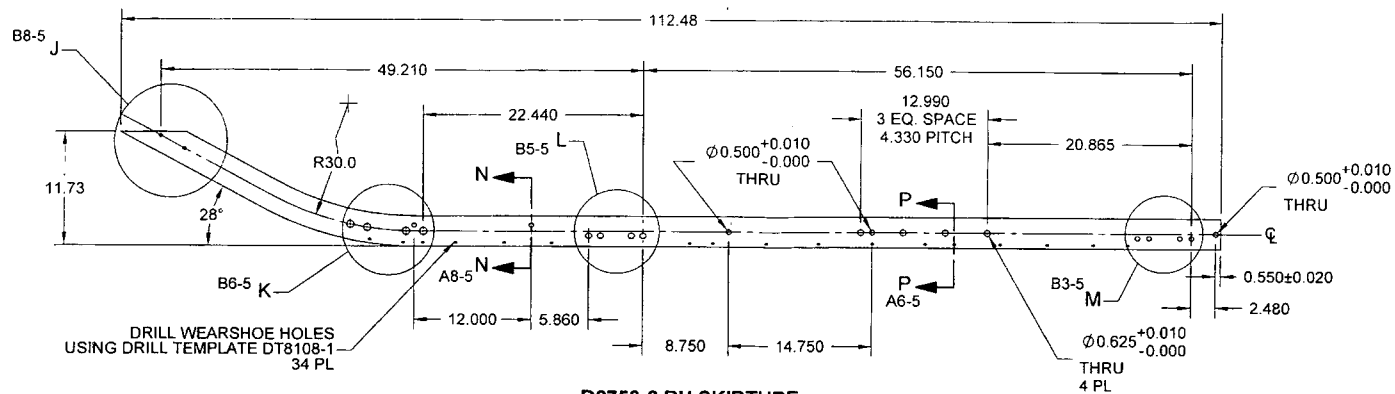
SECTION H-H
SCALE 3X, 4 PL

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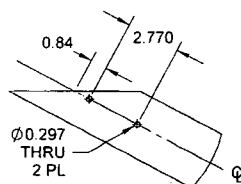
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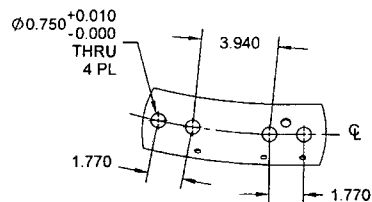
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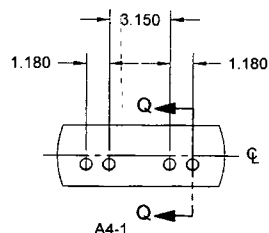
D2750-2 RH SKIDTUBE



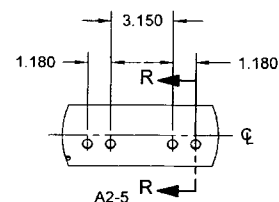
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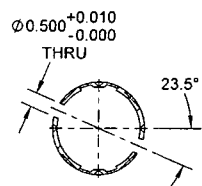
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SCALE 2X



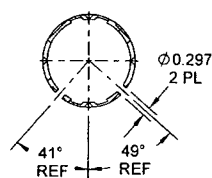
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SCALE 2X



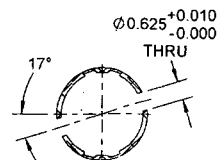
DETAIL M
SCALE 2X



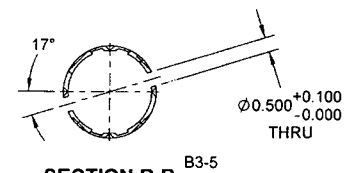
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



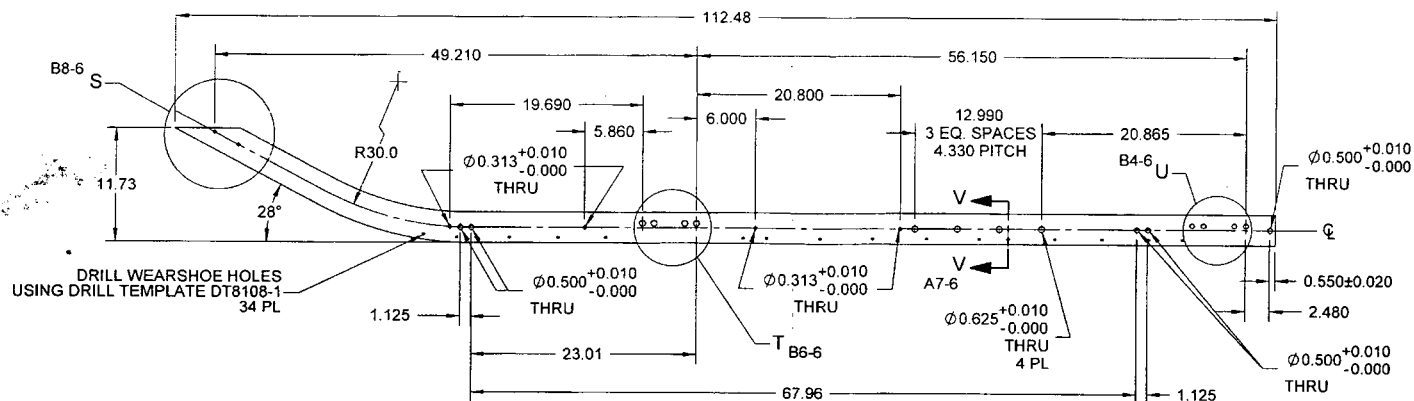
SECTION Q-Q
SCALE 3X, 4 PL



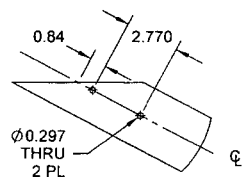
SECTION R-R
SCALE 3X, 4 PL

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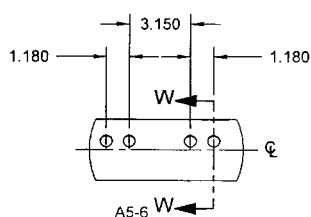
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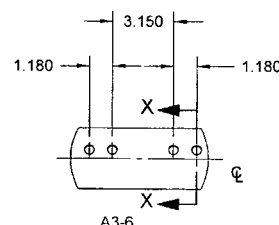
D2750-3 LH SKIDTUBE



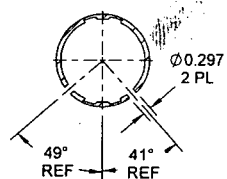
DETAIL S
SCALE 2X



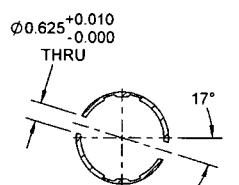
DETAIL T
SCALE 2X



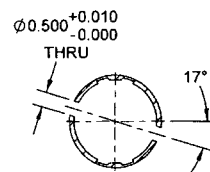
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



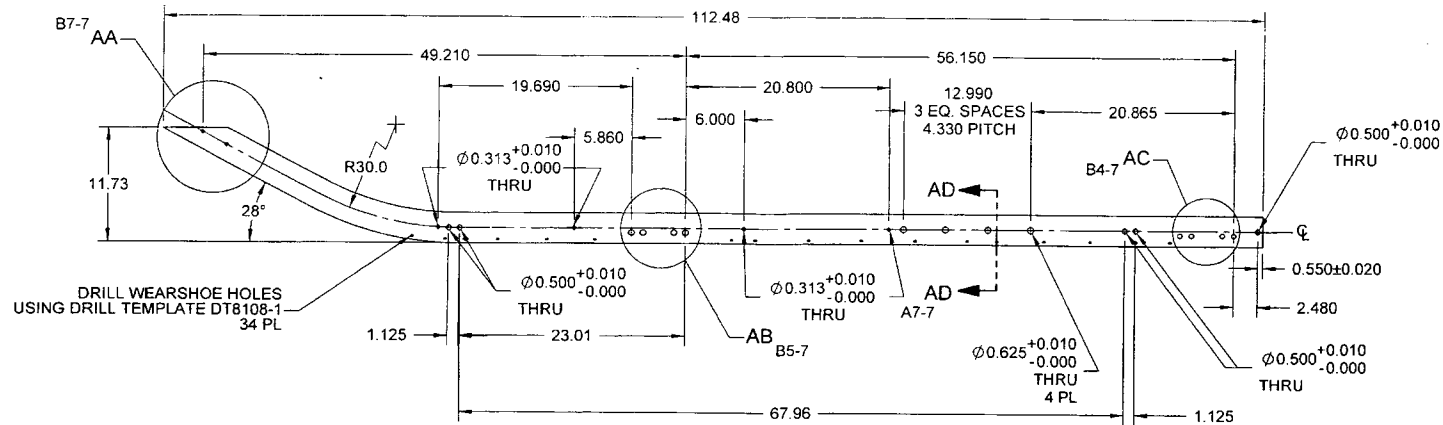
SECTION W-W
SCALE 3X, 4 PL



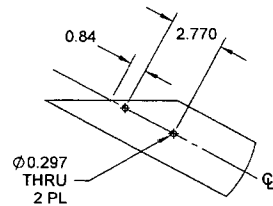
SECTION X-X
SCALE 3X, 4 PL

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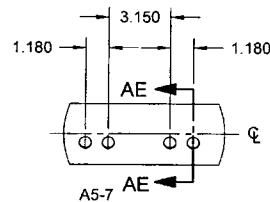
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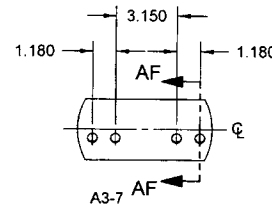
D2750-4 RH SKIDTUBE



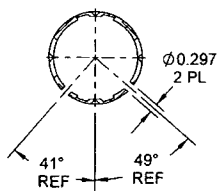
DETAIL AA
SCALE 2X



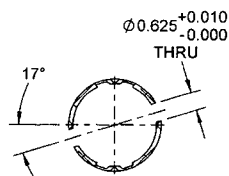
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SCALE 2X



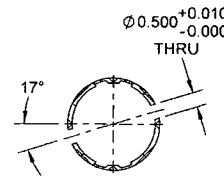
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



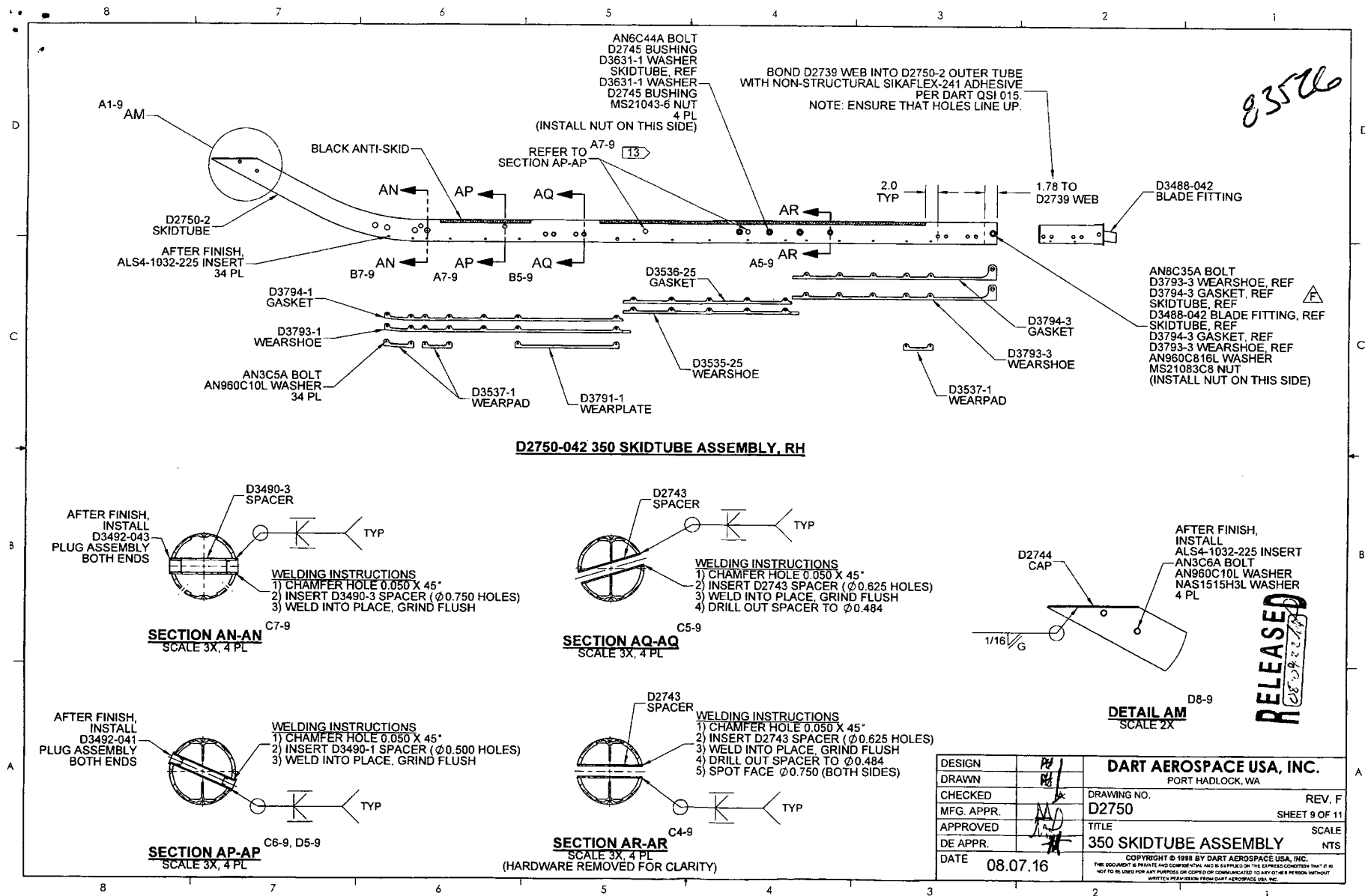
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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8

7

6

5

4

3

2

1

A1-10

AS

BLACK ANTI-SKID

A4-10

REFER TO
SECTION AW-AWAN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL BOLT ON THIS SIDE)

(INSTALL BOLT ON THIS SIDE)

AT

AU

AV

2.0
TYP1.78 TO
D2739 WEBBOND D2739 WEB INTO D2750-3 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.D3488-041
BLADE FITTINGD2750-3
SKIDTUBEAFTER FINISH,
ALS4-1032-225 INSERT
34 PLREFER TO
SECTION AU-AU

A7-10

AU

AV

AW

B4-10

A4-10

D3794-1
GASKETD3536-25
GASKET

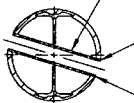
A7-10

AU

AV

B4-10

A4-10

D3535-25
WEARSHOED3794-3
GASKETD3793-3
WEARSHOED3537-1
WEARPADAN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)AN3C5A BOLT
AN960C10L WASHER
34 PLD3537-1
WEARPADD3791-1
WEARPLATE**D2750-043 350 SKIDTUBE ASSEMBLY, LH**D2743
SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484

SECTION AT-AT
SCALE 3X, 4 PL

D6-10

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484
5) SPOT FACE Ø 0.750 (BOTH SIDES)

D2743
SPACER**SECTION AV-AV**
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

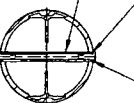
D4-10

D2744
CAP

1/16" G

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL**DETAIL AS**
SCALE 2X

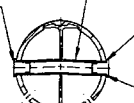
D8-10

AFTER FINISH,
INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDSD3490-5
SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø 0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AU-AU
SCALE 3X, 4 PL

D5-10, D6-10

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDSD3490-1
SPACER**SECTION AW-AW**
SCALE 3X, 4 PL

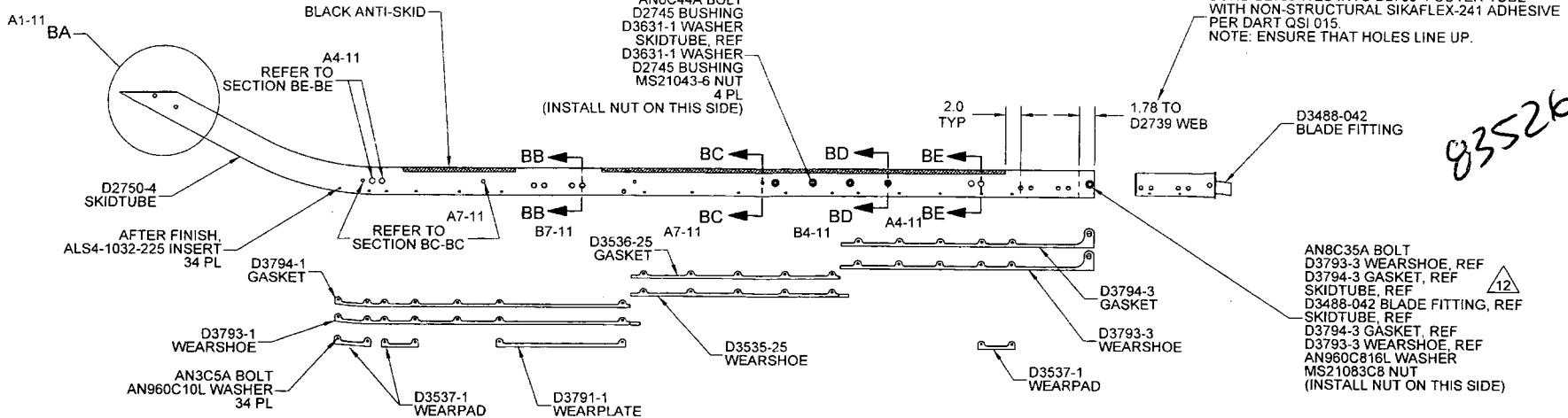
D4-10, D7-10

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

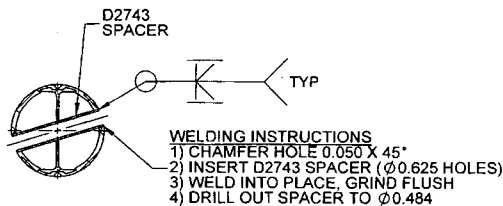
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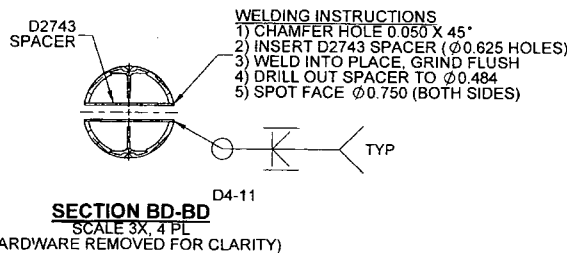
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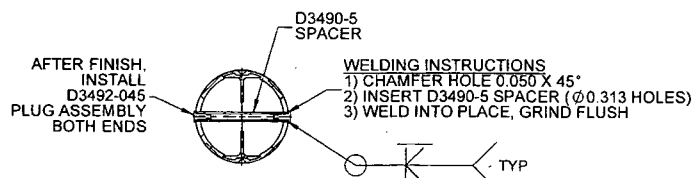
D2750-044 350 SKIDTUBE ASSEMBLY, RH



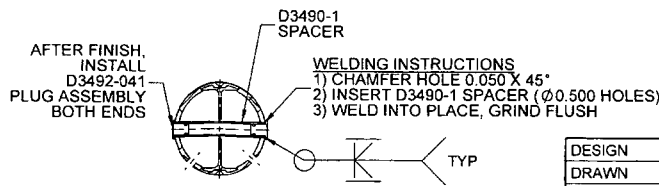
SECTION BB-BB
SCALE 3X, 4 PL



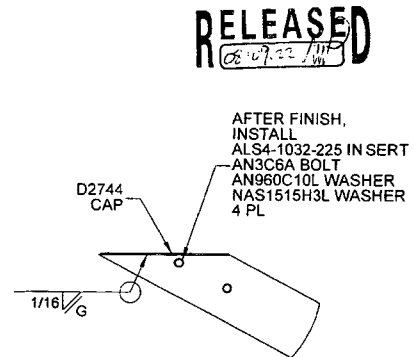
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NO. 289

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 81400
Part number: A350-636-016
Description: Shielding
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier David Sewel Date of Test Coupon 12.04.17
Welder Barclay Elliott Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld